

Work Order ID 128133

January-07-15 2:47:00 PM

128133

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Item ID: D2673-34 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: End Plate
 Start Date: 1/07/15 Start Qty: 40.00 *40* 56 Cust Item ID:
 Required Date: 1/09/15 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: V Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2673	Rev B

100	FLOW WATER JET	0.00				56	0		DAS 23 9-89 15-1-8
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2673 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Debur if necessary								
6061.080									

110	QC2- Inspect parts off machine FAI/FAIB	0.00				56	0		DAS 23 9-89 15-1-8
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00				(56)			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									

JAN 09 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>W A003</u>	0.00				<u>56</u>		<u>DA 15/1/12</u>	
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00						<u>MLS 15-DI-13</u>	
Quality Control									

DA 15-1-12

Linda Lacelle

From: Laura McClelland <lmcclelland@aviall.com> on behalf of Toronto Inbound Queue <toronto@aviall.com>
Sent: January-07-15 2:51 PM
To: Linda Lacelle
Cc: Jean-Luc Menard
Subject: Re: FW: Helicoils for 350 cck

Hi Linda - Happy New Year

100 each of the MS21209F5-20 will be 0.86 each, stock at factory so allow 3-4 days after order

Thank you
Laura

Aviall Toronto
7425 Tranmere Drive, Unit 2
Mississauga, Ontario
L5S 1L4
Ph. 905-676-1695
Fax 905-676-9046
Email: toronto@aviall.com

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Subject to MFG price changes.

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From:	Linda Lacelle <llacelle@dartaero.com>
To:	"Laura McClelland (lmcclelland@aviall.com)" <lmcclelland@aviall.com> ,
Cc:	Jean-Luc Menard <jmenard@dartaero.com>
Date:	01/07/2015 01:34 PM
Subject:	FW: Helicoils for 350 cck

Hi Laura,
Please advise price and delivery on 100 x MS21209F5-20 helicoils

Thx
Linda

From: Jean-Luc Menard
Sent: January-07-15 1:17 PM
To: Linda Lacelle
Subject: Helicoils for 350 cck

Better get these ordered also pls:
MS21209F5-20

2 per kit required.
JL

Jean-Luc Ménard
Production Engineering Supervisor

DART AEROSPACE
T 1 613 632-5200 > 227
F 1 613 632-5246
1 800 556- 4166
www.dartaerospace.com<<http://www.dartaerospace.com/>>

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[attachment "image001.png" deleted by Laura McClelland/Toronto/Aviall]

Picklist Print

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Work Order ID: 128133

128133

Parent Item: D2673-34

D2673-34

Parent Item Name: End Plate

Start Date: 1/07/15

Required Date: 1/09/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP C02.01.14Removed deburr and inspect level 5NG/EC
 IPP Rev:D Now 6061-T6 06-06-23 JLM
 IPP Rev:C Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	303.4498	0.052	6 4			DAS 23 9-88 15-1-8
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		303.4498							
				m130530		67							
				m130560		236.4498				130560			

M6061T6S 080

6061-T6 .080 Sheet

128133

☒ **First Article** ☐ **Prototype**

DAS

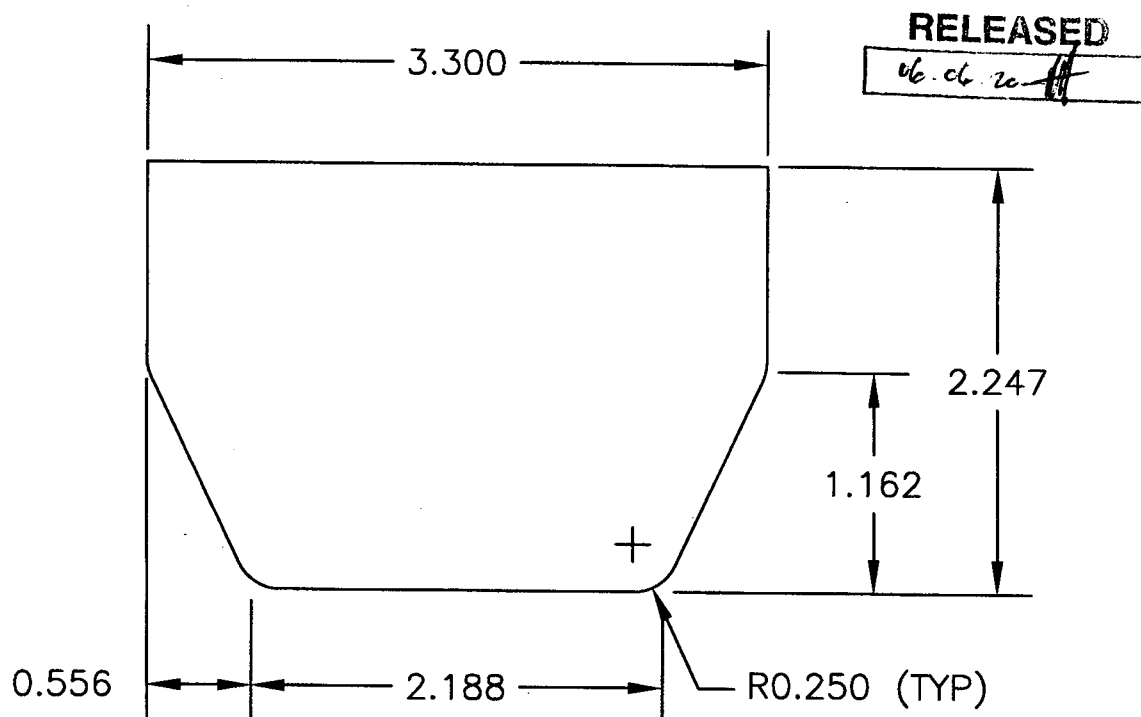
DAS



DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2673	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE END PLATE	SCALE 1:1
A	97.05.06	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

END PLATE FOR D2244 EXTRUSION CUT AT 34°

Mo 128/33D2673-34NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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